

Work Order ID 48676

July 2, 2009 3:05:28 PM



Page 1

Item ID: D3789-7

Accept



Setup Start



Revision ID: A

Stop



Item Name: Clamp

Start Date: 07/02/2009 Start Qty: 15.00



Cust Item ID:

Required Date: 07/02/2009 Req'd Qty: 15.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3789

Rev A

100

0.00



PURCHASING

Purchasing

Purchasing

Memo

0.00

Send Blanks To: Metec/Mast Precision
Machining I/P/O: _____

Machine D3789-7 as per Dwg D3789

(15)

mt 07/07/14

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Packaging

Memo

0.00

N/A

120

0.00



QC6- Inspect dimensions to drawing

QC 2

Memo

0.00

Quality Control

mt 07/07/14

(15)

mt 07/07/15

(15)

Second Check.

QC8

Work Order ID 48676

July 2, 2009 3:05:28 PM



Page 2

Item ID: D3789-7

Accept



Setup Start



Revision ID: A

Stop



Item Name: Clamp

Start Date: 07/02/2009 Start Qty: 15.00



Cust Item ID:

Required Date: 07/02/2009 Req'd Qty: 15.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

X15 umd 09/07/15

0.00

HandFinish

Memo

Hand Finishing

140

QC3- Inspect Part Finish

0.00

X15 09-07-15

0.00

QC

Memo

Quality Control

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

Powdercoat

Memo

Powder Coating

*****Mask bearing bore prior to powder coat*****

TIME: FINISH TIME: OVEN TEMPERATURE:

1:49pm 320°F

START 1:10pm

M112148

09-07-15 X15

SA

Work Order ID 48676

July 2, 2009 3:05:28 PM



Page 3

Item ID: D3789-7

Accept



Setup Start



Revision ID: A

Stop



Item Name: Clamp

Start Date: 07/02/2009 Start Qty: 15.00



Cust Item ID:

Required Date: 07/02/2009 Req'd Qty: 15.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

09-07-15 (15)



QC

Memo

0.00

Quality Control

48

170

Identify as per dwg & Stock Location: 467

0.00



Packaging

Memo

0.00

Packaging

9/7/16 (15K) 5P

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/16 JF
mf 09-07-16

Picklist Print

Page 1

July 2, 2009 3:05:28 PM

Work Order ID: 48676

Parent Item: D3789-7RevA

Parent Item Name: Clamp

Comments:



Start Date: 07/02/2009

Required Date: 07/02/2009

Start Qty: 15.00

Required Qty: 15.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423RevB1		Manufactured	No			100	f	767.4300	1.1053			



Lug Extrusion

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

767.43

43722

219.5

44529

22.39

45800

525.54

43722

1.181

mmp
09/07/14

Dart Aerospace Ltd

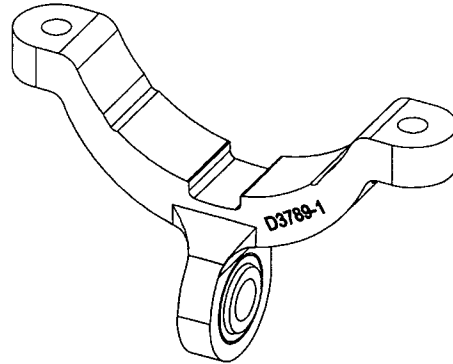
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

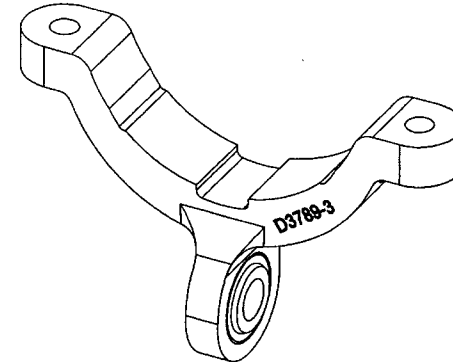
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

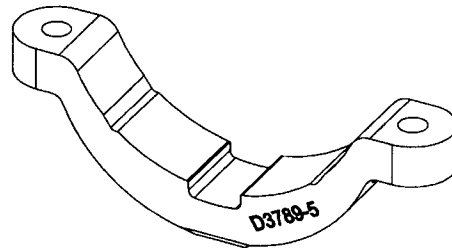
NOTE: Date & initial all entries



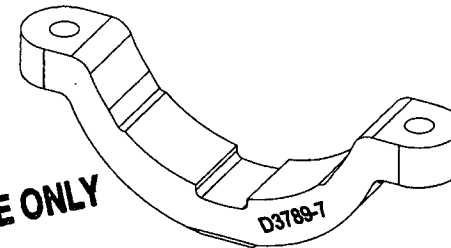
D3789-1 CLAMP



D3789-3 CLAMP



D3789-5 CLAMP



D3789-7 CLAMP

REFERENCE ONLY

DEO ATTACHED

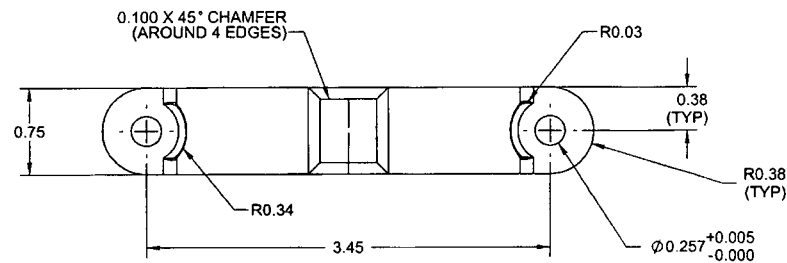
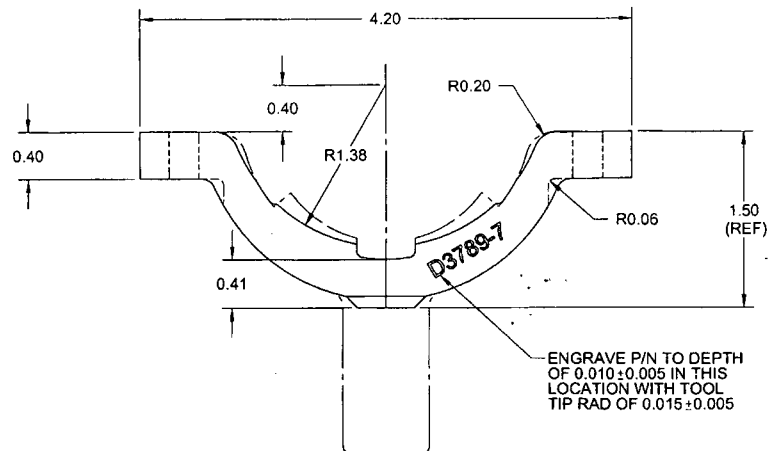
RELEASE
08/12/21

NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N AS SHOWN
- 7) WEIGHT: D3789-1, 0.16 lbs
D3789-3, 0.16 lbs
D3789-5, 0.14 lbs
D3789-7, 0.14 lbs
- 8) STAKE D2611 BEARING 4 PLACES EACH SIDE AFTER POWDER COAT
- 9) PART IS SYMETRICAL ABOUT ϕ

A		NEW ISSUE		HS	08.05.21
REV.		DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	HS				
CHECKED		DRAWING NO. D3789		SHEET 1 OF 5	
MFG. APPR.		TITLE CLAMP		SCALE	
APPROVED				NTS	
DE APPR.					
DATE	08.05.21				

COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD



REFERENCE ONLY

D3789-7 CLAMP

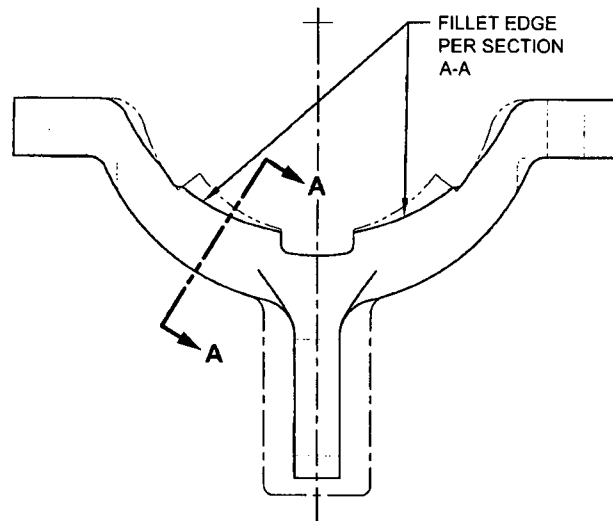
DEO ATTACHED

RELEASED
28/12/21

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.		D3789	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
DATE	08.05.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

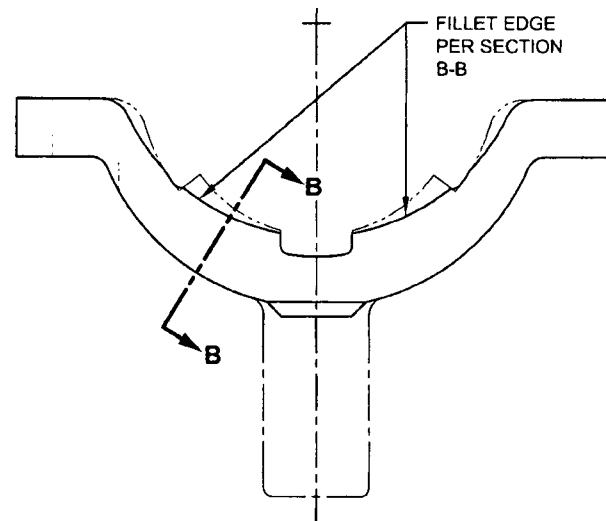
DRAWING NO. D3789	TITLE CLAMP	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3789-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>AJS</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 09.04.20	DATE 09.04.23	DATE 09.04.23	DATE 09/04/23		DATE 09/04/23		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



D3789-1 CLAMP

D3789-3 CLAMP



D3789-5 CLAMP

D3789-7 CLAMP



R0.06 MIN - R0.10 MAX
2PL

SECTION A-A
SCALE 2X

SECTION B-B
SCALE 2X

REFERENCE ONLY

RELEASED
09/05/04 [Signature]

SEE PAR 122 FOR FURTHER DETAILS

COPYRIGHT © 2009 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD